

Work Order ID 58641

Wednesday, May 12, 2010 1:42:18 PM



Page 1

Item ID: D3684-047

Accept



Setup Start



Revision ID:

Item Name: FWD LEG ASS'Y

Stop



Start Date: 5/13/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: UMF

Date: 10-5-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Draw Nbr****Revision Nbr**

D3684

Rev D

100



Packaging

Packaging

**Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

0.00

Sp 10/06/22

FT

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

Small Fab

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

**Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

7

Sp 10/06/22

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

0.00

8/10/06/22

Draw
Number

Rev.

Draw

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 1390

0.00

0.00

00/06/22

(X7)

10/06/22 (7)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

00/06/22

10/06/23 (J)10/06/22

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Picklist Print

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Work Order ID: 58641



Parent Item: D3684-047



Parent Item Name: FWD LEG ASS'Y

Start Date: 5/13/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM

Start Qty: 8.00

IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC

IPP

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Required Qty: 8.00

AN3C12A



Purchased

No

110

Each

104.0000

2



Bolts

Location

ST351

Loc Qty

104

Loc Code

14

SB 18/06/22

D3688-1



Manufactured

No

112314

110

Each

7.0000

1



STUD

Location

ST080

Loc Qty

7

Loc Code

7

SB 18/06/22

D3689-1



Manufactured

No

50932

110

Each

16.0000

1



SLEEVE

Location

ST082

Loc Qty

16

Loc Code

7

SB 10/06/22

D3691-1



Manufactured

No

55638

110

Each

1.0000

1



STUD

Location

ST082

Loc Qty

1

Loc Code

7

SB 10/06/22

D 58631

0

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IPP

Required Qty: 8.00

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

D3692-1



Manufactured

No

110

Each

521.0000

4



SPACER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	521	
50736	113	
51467	408	

28

SP 10/06/22

D3693-1



Manufactured

No

110

Each

63.0000

1



Rod End Bearing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	63	
50734	63	

7

SP 10/06/22

MS21043-3



Purchased

No

110

Each

3,635.000

2



Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	80	
103691	80	
ST301	3555	
112314	3555	

10/06/22

NAS509-12C



Purchased

No

110

Each

69.0000

1



Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	69	
112453	69	

7

10/06/22

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IPP

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Required Qty: 8.00

NAS509L12C



Purchased

No

110

Each

74.0000

1



Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	74	
112314	64	
112828	10	

7

83 1006/22

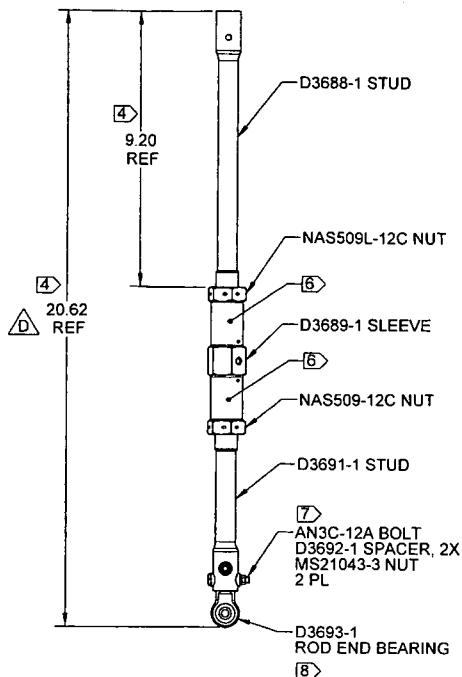
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

RELEASED
2010-03-15
JW

NOTES:

- 1) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE 10.03.03		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED OR IN ANY WAY COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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